

shp 09/04

Work Order ID 57343

April 6, 2010 7:40:09 AM



Page 1

Item ID: D212-725-1-227

Accept



Setup Start



Revision ID: DXXXXXX

Item Name: bracket

Stop



Start Date: 4/06/10 Start Qty: 2.00



Cust Item ID:

Required Date: 4/08/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: 

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D212-725-1

Rev B 

100



Waterjet

FLOW WATER JET


0.00


Memo

0.00


FLOW CNC Waterjet

1-Cut as per Dwg D212-725-1

Dwg Rev: 

Prog Rev: 

2-Deburr if necessary

-7m.  10/04/07

(9X)

10-4-7

(9)

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

10-4-7

120



QC


Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

 10/04/07

(9X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57343

April 6, 2010 7:40:09 AM



Page 2

Item ID: D212-725-1-227

Accept



Setup Start



Revision ID:

Item Name: bracket

Stop



Start Date: 4/06/10

Start Qty: 2.00



Required Date: 4/08/10

Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

Bend as per dwg
NC BRAKE

0.00

0.00

SO 10/04/08

8

8

PTO

Brake NC

Memo

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Subelos

(8)

Memo

150



Packaging

Packaging



Identify as per dwg & Stock Location: 367

0.00






0.00

C10/4/8 (8)

Memo

W/O: 57343		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
100408	Dwg Leader box	update drawing box to Rev. G per WCK below Person change		10.04.12		 100408	 100408

Part No: D212-725-1-227 PAR #: _____ Fault Category: Eng - drawing NCR: Yes No DQA: Yes Date: 100408
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 10/04/12

NCR: 57343		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
100408	PSD	RF changed drug to Rev G April 1 part scrap. R.C. drawing (drips not corrected) to thicker material Rev. F attached	 100408	Eng scrap Qty 1. No replace.	 10/04/08	 10/04/08	 100408	 100408

NOTE: Date & initial all entries

Work Order ID 57343

April 6, 2010 7:40:10 AM



Page 3

Item ID: D212-725-1-227

Accept



Setup Start



Revision ID:

Stop



Item Name: bracket

Start Date: 4/06/10 Start Qty: 2.00



Required Date: 4/08/10 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/12 JG

U 10-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 6, 2010 7:40:08 AM

Page 1

Work Order ID: 57343

Parent Item: D212-725-1-227

Parent Item Name: bracket



Comments: IPP Rev:A new issue DD 10.03.16 verified by:EC

Start Date: 4/06/10

Required Date: 4/08/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	89.0000	0.2737	1.3		
304/316 .040 Sheet 												

1810-4-7

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT20

89

112885

25

113062

64

304 .050 112178

112178

(9)

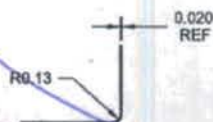
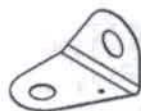
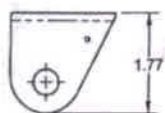
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

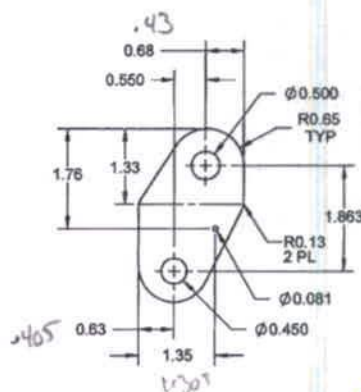
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D212-725-1-227 BRACKET
(MAKE FROM D212-725-1-227F FLAT PATTERN)

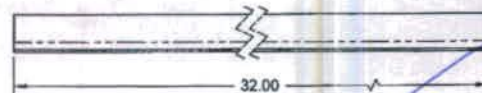


D212-725-1-227F FLAT PATTERN

D212-725-1-227 NOTES:

- 1) MATERIAL: AISI 301 1/2 HARD STAINLESS STEEL 0.020 (25 GAUGE) SHEET PER AMS-5518
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs

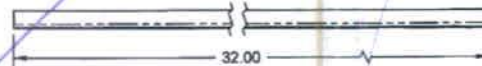
changed to Rev G RF



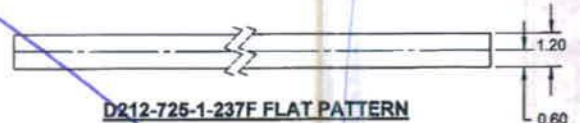
D212-725-1-235 ANGLE
(MAKE FROM D212-725-1-235F FLAT PATTERN)



D212-725-1-235F FLAT PATTERN



D212-725-1-237 ANGLE
(MAKE FROM D212-725-1-237F FLAT PATTERN)



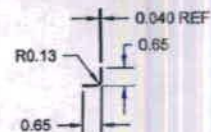
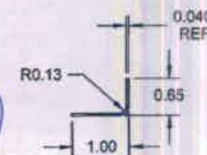
D212-725-1-237F FLAT PATTERN



D212-725-1-235/-237 NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A

no 57343



RELEASED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. F
MFG. APPR.		D212-725-1	SHEET 00 OF 04
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	09.02.02	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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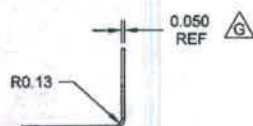
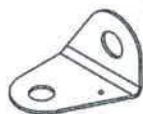
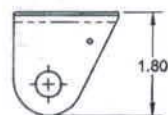
SHEET #	REV.	DATE	NOTES
75	A	N/A	N/A
	B	N/A	N/A
	C	N/A	N/A
	D	N/A	N/A
	E	08.09.17	ADDED D212-725-1-215
	F	09.02.02	NO CHANGE
	G	10.02.12	NO CHANGE
76	A	N/A	N/A
	B	N/A	N/A
	C	N/A	N/A
	D	N/A	N/A
	E	08.09.17	ADDED D212-725-1-217
	F	09.02.02	NO CHANGE
	G	10.02.12	NO CHANGE
77	A	N/A	N/A
	B	N/A	N/A
	C	N/A	N/A
	D	N/A	N/A
	E	08.09.17	ADDED D212-725-1-219
	F	09.02.02	NO CHANGE
	G	10.02.12	NO CHANGE
78	A	N/A	N/A
	B	N/A	N/A
	C	N/A	N/A
	D	N/A	N/A
	E	08.09.17	ADDED D212-725-1-223/-221
	F	09.02.02	NO CHANGE
	G	10.02.12	NO CHANGE
79	A	N/A	N/A
	B	N/A	N/A
	C	N/A	N/A
	D	N/A	N/A
	E	08.09.17	ADDED D212-725-1-225
	F	09.02.02	RE-DESIGN D212-725-1-225 (ZN C4-79)
	G	10.02.12	NO CHANGE
80	A	N/A	N/A
	B	N/A	N/A
	C	N/A	N/A
	D	N/A	N/A
	E	08.09.17	ADDED D212-725-1-227
	F	09.02.02	ADDED D212-725-1-235/-237
	G	10.02.12	0.050 WAS 0.020 (ZN D6-80, A8-80); ADD DIMENSIONS (ZN B8-80, B6-80)
81	A	N/A	N/A
	B	N/A	N/A
	C	N/A	N/A
	D	N/A	N/A
	E	08.09.17	ADDED D212-725-1-231/-233
	F	09.02.02	REVISED FINISHING NOTE; RE-DESIGN D212-725-1-231

RELEASED

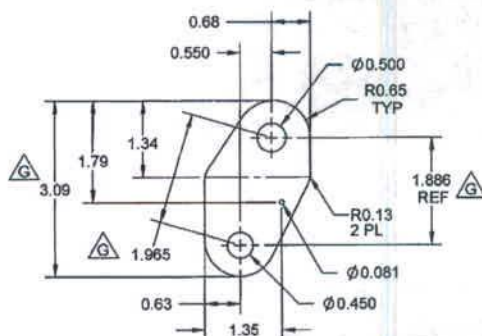
10.03.31

57343

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MP</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>MP</i>	D212-725-1	SHEET XIII OF XIV
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	212S DETAIL PARTS	NTS
DATE	10.02.12	COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

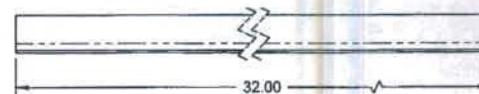


D212-725-1-227 BRACKET
(MAKE FROM D212-725-1-227F FLAT PATTERN)

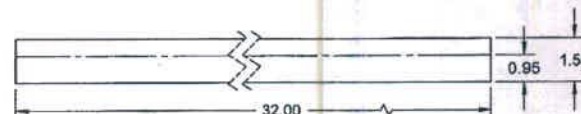
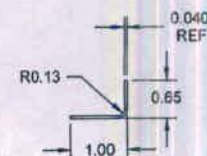


D212-725-1-227F FLAT PATTERN

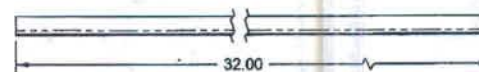
- D212-725-1-227 NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.02 lbs



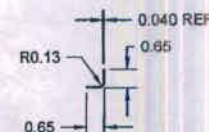
D212-725-1-235 ANGLE
(MAKE FROM D212-725-1-235F FLAT PATTERN)



D212-725-1-235F FLAT PATTERN



D212-725-1-237 ANGLE
(MAKE FROM D212-725-1-237F FLAT PATTERN)



D212-725-1-237F FLAT PATTERN

- D212-725-1-235/237 NOTES:**
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
REF. DART SPEC. M2024T3S.040
 - 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: N/A

RELEASED

10-0731

57343

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D212-725-1	SHEET 80 OF 84
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	212S DETAIL PARTS	NTS
DATE	10.02.12	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SHOWN ON THE BASIS OF A CONFIDENTIALITY AGREEMENT. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

L Lacelle

From: David Shepherd [dshepherd@dartaero.com]
Sent: April 6, 2010 9:30 AM
To: 'L Lacelle'
Cc: 'David Duval'
Subject: RE: D212-725-1-227

Linda/Dave,

Sorry for the delays on this, but per D212-725-1 Rev G that is being released TODAY, the parts are to be made from 0.050" 304/316 stainless steel. Eagle is OK with this.

David

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Tuesday, April 06, 2010 7:09 AM
To: 'Robert Fuentes'; 'David Shepherd'
Cc: 'David Duval'
Subject: RE: D212-725-1-227

I know we have resolved the mat'l issue for the D4083-1 bracket, what have we decided about the D212-725-1-227?

Thx
LL

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: March 16, 2010 11:08 AM
To: 'Robert Fuentes'; 'David Shepherd'
Cc: 'David Duval'
Subject: FW: D212-725-1-227

Hi guys,
Could you please advise if we can use 304SS for this one?
Thx
LL

From: David Duval [mailto:dduval@dartaero.com]
Sent: March 16, 2010 11:00 AM
To: 'L Lacelle'
Subject: RE: D212-725-1-227

No answer

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: March 11, 2010 8:00 AM
To: 'David Duval'
Subject: RE: D212-725-1-227

Ohhhhhhhhhh yeah!!

4/06/10

From: David Duval [mailto:dduval@dartaero.com]
Sent: March 11, 2010 7:54 AM
To: 'L Lacelle'
Subject: RE: D212-725-1-227

I did yesterday route and dxf done but not the bom because of the material remember the e-mail I sent you.

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: March 11, 2010 7:34 AM
To: 'David Duval'
Subject: D212-725-1-227

Hi Dave,
We rec'd an order from Eagle for these, could you please make bom/route?

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd

No virus found in this incoming message.
Checked by AVG - www.avg.com
Version: 8.5.437 / Virus Database: 271.1.1/2793 - Release Date: 04/05/10 18:32:00

4/06/10

L Lacelle

From: Angela Albert [aalbert@eaglecopters.com]
Sent: April 6, 2010 9:29 AM
To: 'L Lacelle'
Subject: RE: need this company opened for S/O outside service
Okay the Customer code is CC-GEO001

ANGELA ALBERT
INTERMEDIATE ACCOUNTANT
Eagle Copters Maintenance Ltd/Dart Aerospace
Phone: (403) 250-7370 Ext 107
Fax line: (403) 291-1509
Email: aalbert@eaglecopters.com
Website: www.eaglecopters.com

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Tuesday, April 06, 2010 7:22 AM
To: 'Angela Albert'
Subject: RE: need this company opened for S/O outside service

No, put it 1000.00 pls
Thx
L

From: Angela Albert [mailto:aalbert@eaglecopters.com]
Sent: April 6, 2010 9:17 AM
To: 'L Lacelle'
Subject: RE: need this company opened for S/O outside service

What is his credit limit? 5000.00?

ANGELA ALBERT
INTERMEDIATE ACCOUNTANT
Eagle Copters Maintenance Ltd/Dart Aerospace
Phone: (403) 250-7370 Ext 107
Fax line: (403) 291-1509
Email: aalbert@eaglecopters.com
Website: www.eaglecopters.com

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Tuesday, April 06, 2010 6:57 AM
To: aalbert@eaglecopters.com
Subject: need this company opened for S/O outside service

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd

4/06/10

L Lacelle

From: Robert Fuentes [rfuentes@dartaero.com]
Sent: April 6, 2010 10:18 AM
To: 'L Lacelle'; 'David Shepherd'
Cc: 'David Duval'
Subject: RE: D212-725-1-227

David has updated drawing, ready to release, material for D212-725-1-227 is 304/316 SS annealed 2B finish 0.050" (18 Gauge) sheet.

Roberto

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Tuesday, April 06, 2010 7:09 AM
To: 'Robert Fuentes'; 'David Shepherd'
Cc: 'David Duval'
Subject: RE: D212-725-1-227

I know we have resolved the mat'l issue for the D4083-1 bracket, what have we decided about the D212-725-1-227?

Thx
LL

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: March 16, 2010 11:08 AM
To: 'Robert Fuentes'; 'David Shepherd'
Cc: 'David Duval'
Subject: FW: D212-725-1-227

Hi guys,
Could you please advise if we can use 304SS for this one?
Thx
LL

From: David Duval [mailto:dduval@dartaero.com]
Sent: March 16, 2010 11:00 AM
To: 'L Lacelle'
Subject: RE: D212-725-1-227

No answer

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: March 11, 2010 8:00 AM
To: 'David Duval'
Subject: RE: D212-725-1-227

Ohhhhhhhhhhhh yeah!!

From: David Duval [mailto:dduval@dartaero.com]

4/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

* NOTE: Date & initial all entries